

Work Order ID 134493

Wednesday, July 08, 2015 3:16:59 PM

134493

Page 1

Item ID: D119-796-251 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AFT Crosstube Installation with Step (no hardware)
 Start Date: 7/07/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUL 10 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-251	D								

110 Document Control 0.00
110
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels as per PPP D119-796-251 chg 002

N/A MLJ OCT 05 2015

120 Pick Kit 0.00
120 Packaging
 Packaging Memo 0.00
 Packaging

1 15-10-1
 DAS
 41
 9.8

130 Crosstubes 0.00
130 Crosstubes Memo 0.00
 Crosstubes 1- Install step and clamp with the proper position per dwg D119-796-251
 Torque all clamps to 50 IN-LBS max.

1 15-10-1
 DAS
 41
 9.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Start Date: 7/07/15

Start Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

RE-CHECK TORCQUE ON CLAMP AS PER DWG.

DAS

38

9-89

OCT 05 2015

150

Packaging

0.00

150

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-796-251

DAS

41

9-89

15-10-5

For final assembly

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

OCT 05 2015

OCT 05 2015

DQA: _____ Date: _____



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OTHER : _____																					

Picklist Print

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134493

Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D
JLM VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-241		Manufactured	No				Each	0.0000		1			
D119-796-241					135 892				**	1		DAS 41 9.80 15-10-1	
AFT Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	52.0000		4			
D5123-3									**			DAS 41 9.80 15-10-1	
Clamp Cushion													
					133959					4			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				LG055		13							
					133460	13							
				lg55		39							
					126747	12							
					127133	6							
					131871	21							
D5149-043		Manufactured	No				Each	2.0000		2			
D5149-043									**			DAS 41 9.80 15-10-1	
Aft Step Base Assembly													
					135503					2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				LG054		1							
					131333	1							
				LG058		1							
					129892	1							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

Each

176.0000

4

DAS

MS21920-25

41

15-10-1

Clamp

9-8

Location

Loc Qty

Loc Code

FG

10

120920

10

LG050

26

M130400

10

M131367

3

M132169

11

M132522

2

LG057

140

M132674

40

M132675

100

4

DQA: _____ Date: _____



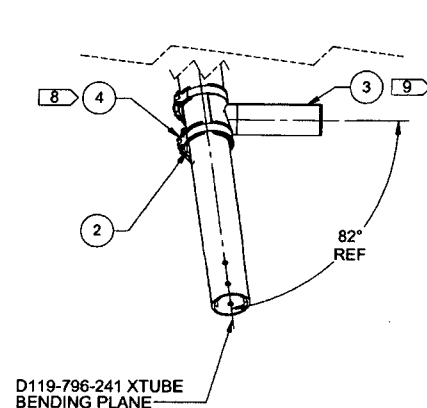
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

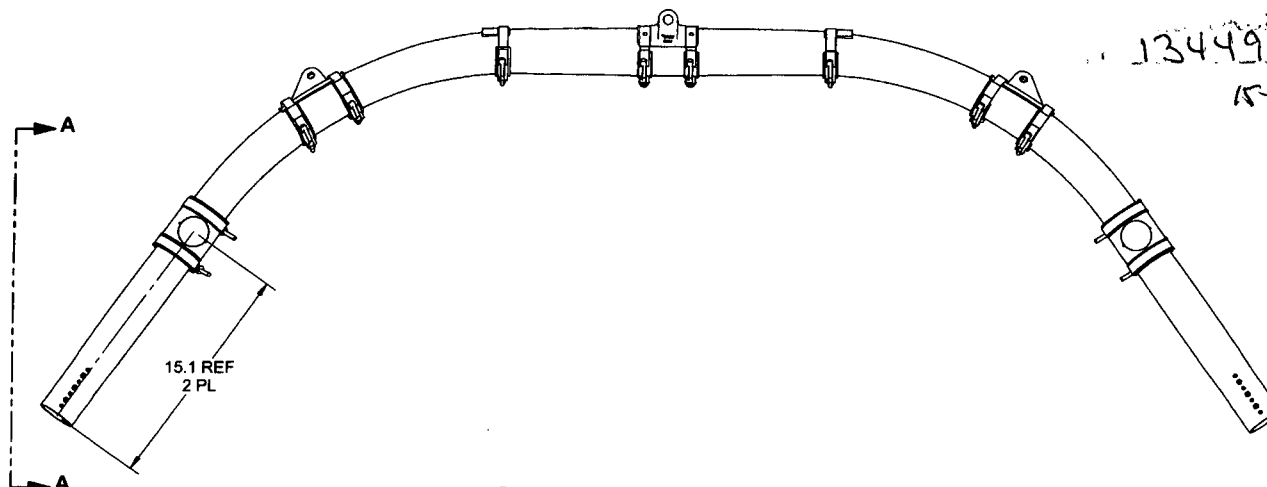
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ITEM	QTY -251	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



SECTION A-A



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-516

D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DD	D119-796-251	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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